

**Work Order ID 52476**

September 25, 2009 1:27:16 PM

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Item ID: PB67-43001-17 **GN**  
Revision ID: B1  
Item Name: Aft Adjustable Blade Support Assembly  
Start Date: 10/05/2009 Start Qty: 2.00  
Required Date: 10/16/2009 Req'd Qty: 2.00  
Reference:

Accept

Setup Start

Stop




Cust Item ID:

Customer:

Approvals: Process Plan: **mf** Date: **09-09-25** Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
B67-43001	Rev B1								
100		0.00							
	Large Fab								
Large Fab	<b>Memo</b>	0.00							
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding □ 2- assemble parts and weld as per dwg								
110		0.00							
	QC9- Inspect visual per QS1004- Fusion Welds								
QC	<b>Memo</b>	0.00							
Quality Control									
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	<b>Memo</b>	0.00							
Quality Control									

**Cpl 09 10 13****PD 09.10.13****>> 809/10/13****(x2)****4**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52476**

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Item ID: PB67-43001-17

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/16/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- grind weld flush in area of PB67-43001-249 only □ 2- install helicol insert as per dwg

SAD

09-10-15

Pl 09 10 14

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

2) Sorlakis

① 2

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

N/A

W/O:		WORK ORDER CHANGES					
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Item ID: PB67-43001-17

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Revision ID: B1

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Start Date: 10/05/2009 Start Qty: 2.00

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME: 7:00am  
COVEN TEMPERATURE: 7:30am FINISH TIME: 3:26pm

elf 09/10/20 (X2) 0

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

PR 09-10-20 0

180

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support 2- assemble as per dwg

pl 09/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 10/16/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

2501/10/20

(X2)

/

Quality Control

200

Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

09.10.20

2

/

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

09/10/20

MF 09-10-20

Quality Control

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 52476

Parent Item: PB67-43001-17RevB1

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS124780 HELICAL INSERT		Purchased	No			180	Each	96.0000	2.0000	STK		
										SAD	09-10-08	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

96

111064

96

MS27039-1-10

Purchased

No

180

Each

37.0000

16.0000



Screw



SAD 09-10-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37

111425

37

NAS1149F0316P

Purchased

No

100

Each

124.0000

16.0000



WASHER



SAD 09-10-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

124

111117

119

111124

5

PB67-43001-249RevB1

Manufactured

No

100

Each

0.0000

2.0000



Inner Tube Bushing



B52480 → 2✓  
Cpl 09.10.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 52476

Parent Item: PB67-43001-17RevB1

Parent Item Name: Aft Adjustable Blade Support Assembly



Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-253RevB1		Manufactured	No			100	Each	12.0000	2.0000			
												
Gusset												

STK  
SEP 09-10-08

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

12

44983

12

100

Each

2.0000

2.0000

2

SEP 09-10-08

PB67-43001-254RevB1

Manufactured No



Gusset

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

2

44982

2

100

Each

5.0000

2.0000

3

3

SEP 09-10-08

PB67-43001-259RevB1

Manufactured No



Inner Tube

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

5

43069

3

44979

2

2

2

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 52476



Parent Item: PB67-43001-17RevB1



Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-71RevB1		Manufactured	No			130	Each	7.0000	2.0000			
PB67-43001-71												

SAD 109-10-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

41512

7

2

PB67-43001-73RevB1

Manufactured No

180

Each

6.0000

2.0000



20 Degree Cover Plate

SAD 109-10-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

41513

6

2

PB67-43001-83RevB1

Manufactured No

180

Each

6.0000

2.0000



PB67-43001-83

SAD 109-10-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

47042

6

2

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Shop Packet Print

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